

Work Order ID 60280

July 1, 2010 10:05:49 AM



Page 1

Item ID: D4051-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Filler

Start Date: 7/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/01/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date: 10/7/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4051

a

100

0.00



Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D4051

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-7-1

(9)

=> Deburr m-*k* 10/07/05 *9x* B10-7-1

?

Work Order ID 60280

July 1, 2010 10:05:49 AM



Page 2

Item ID: D4051-7

Accept



Setup Start



Revision ID:

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Item Name: Filler

Start Date: 7/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/01/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

5/06/10

(49)

130



Packaging

Packaging

Identify as per dwg & Stock Location: 12.1

Memo

0.00

0.00

6/1/10 (9)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

7/07/06

MF 10-7-5

Picklist Print

July 1, 2010 10:05:48 AM

Page 1

Work Order ID: 60280

Parent Item: D4051-7

Parent Item Name: Filler



Start Date: 7/01/10

Required Date: 7/01/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per
dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	70.1439	0.0016	0.003368			



304/316 Sheet .063



H310-7-1

Location

Loc Qty

Loc Code

MAT

70.14389474

111323

0

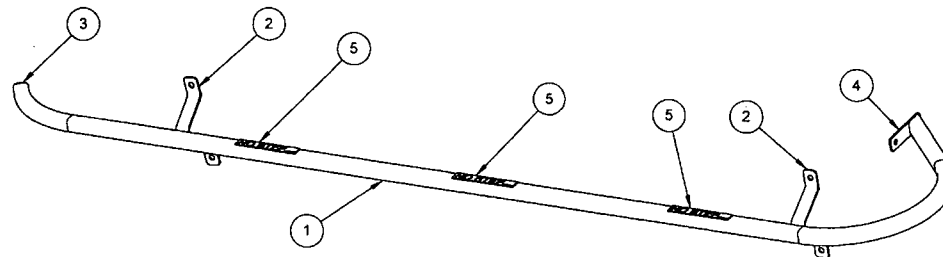
114799

70.1438947

114799

(9)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4051-041	RAPPEL DEFLECTOR ASSY
		X	D4051-042	RAPPEL DEFLECTOR ASSY
1	1	1	D4051-1	RAPPEL DEFLECTOR
2	2	2	D4051-3	BRACKET
3	1	1	D4051-7	FILLER
4	1	1	D4051-5	MOUNTING PLATE
5	3	3	D4051-9	PLACARD



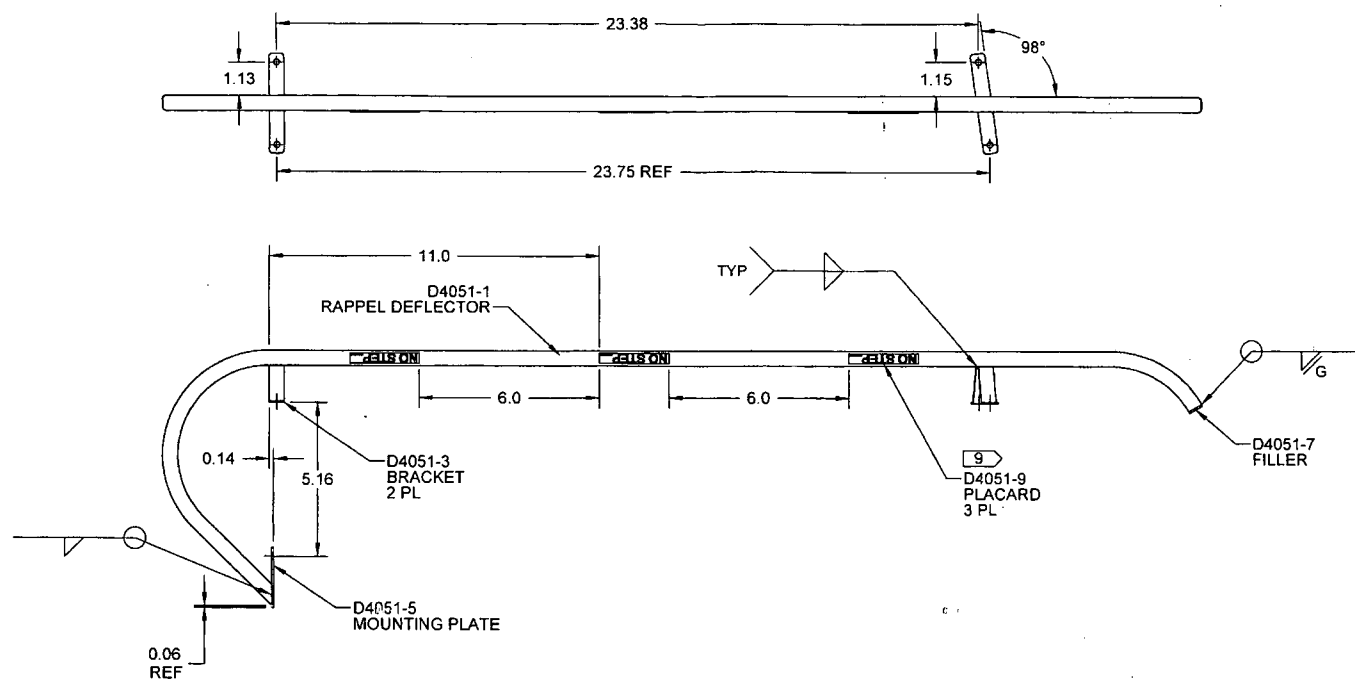
D4051-041 RAPPEL DEFLECTOR ASSY (SHOWN)
D4051-042 RAPPEL DEFLECTOR ASSY (OPPOSITE)

RELEASED
2010-02-16
JMD

CL10/17/01
W10:60280

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	10.01.29		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4051	REV. A
TITLE RAPPEL DEFLECTOR ASSY	SCALE NTS
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


D4051-041 RAPPEL DEFLECTOR ASSY

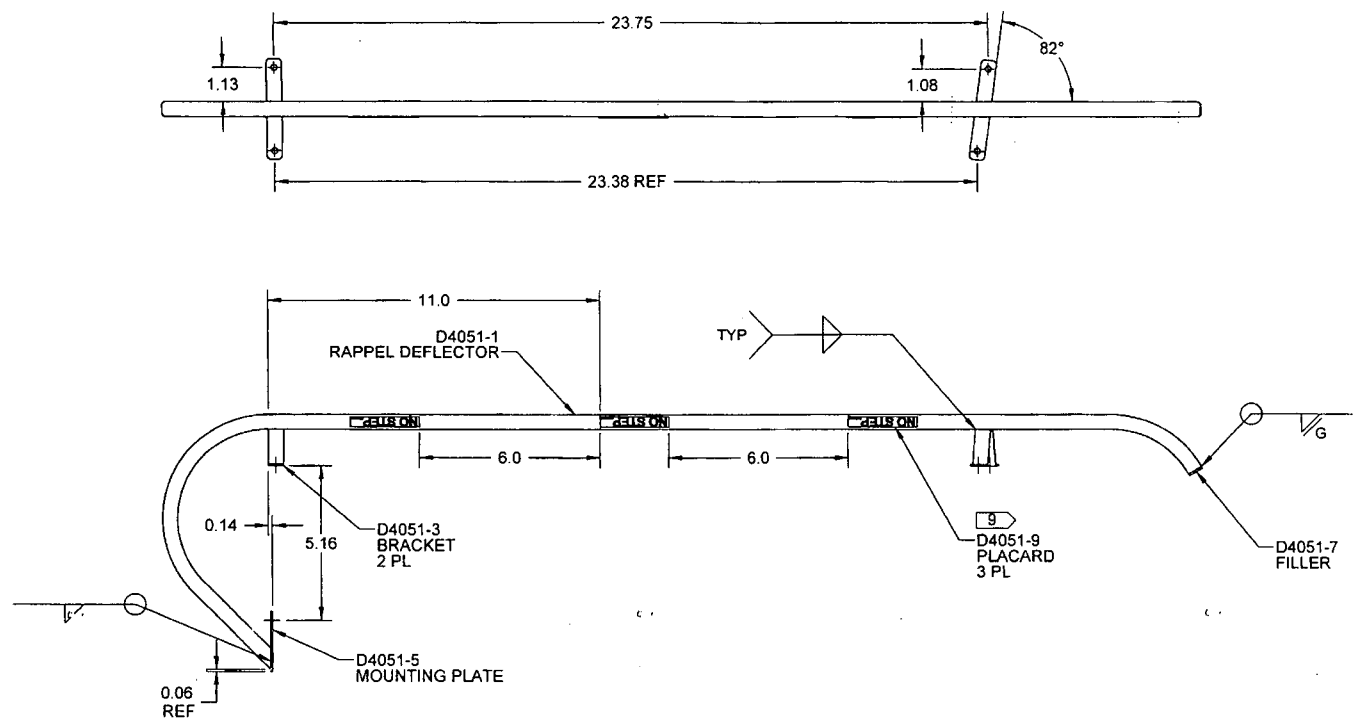
RELEASED
2010-02-16

W/O: 60280

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4051-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.07 lbs
- 8) WELD PER DART QSI 004
- 9) APPLY D4051-9 PLACARD AFTER POWDER COAT

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4051	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		RAPPEL DEFLECTOR ASSY	
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D4051-042 CABLE DEFLECTOR ASSY

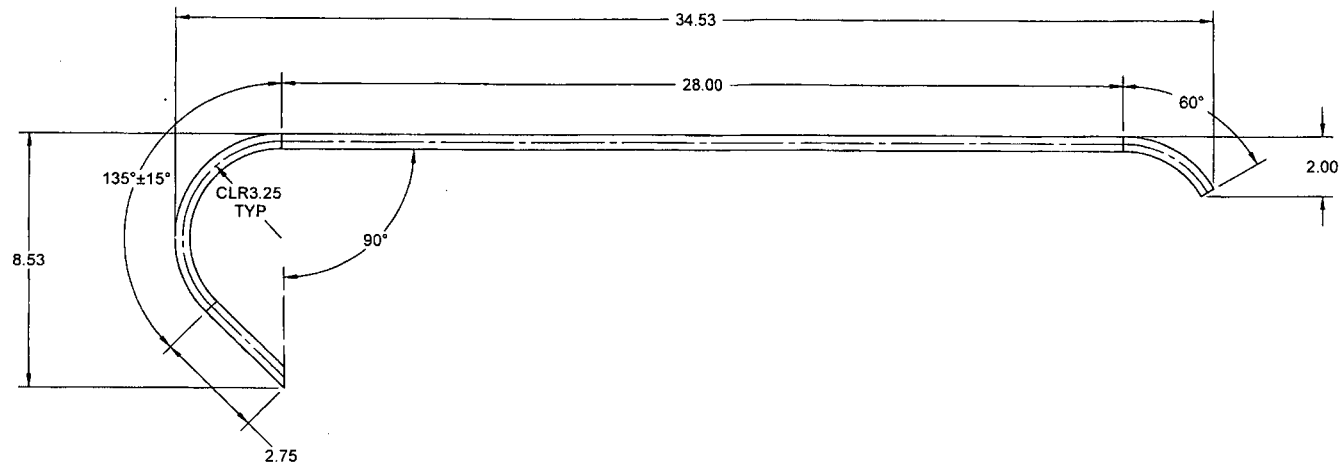
W10.60280

RELEASED
2010-02-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4051-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.07 lbs
- 8) WELD PER DART QSI 004
- 9) APPLY D4051-9 PLACARD AFTER POWDER COAT

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8 D4051-1 RAPPEL DEFLECTOR

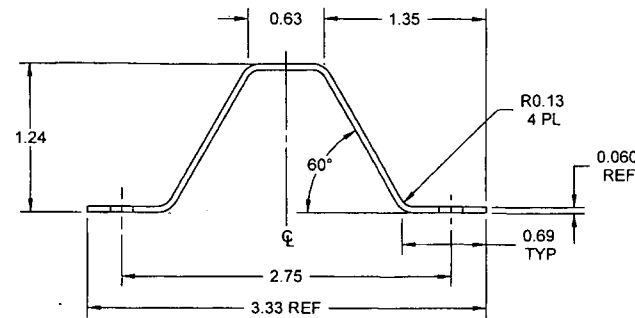
RELEASED
2010-02-16
mp

NOTES:

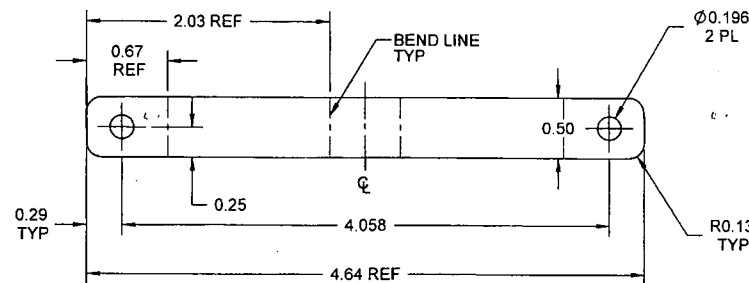
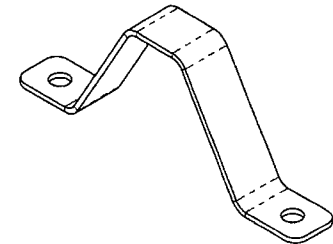
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.98 lbs
- 8) TUBE FLAT LENGTH 43.00 REF

W10. 60280

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D4051-3 BRACKET
(MAKE FROM D4051-3F FLAT PATTERN)







D4051-3F FLAT PATTERN

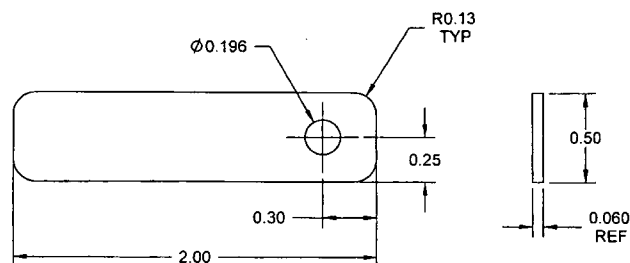
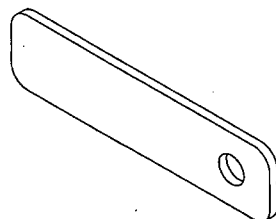
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

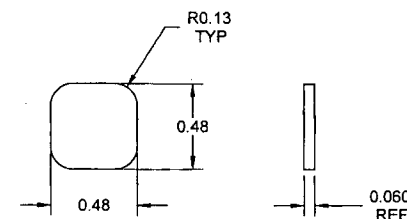
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DE APPR.		RAPPEL DEFLECTOR ASSY	NTS
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D4051-5 MOUNTING PLATE







D4051-7 FILLER

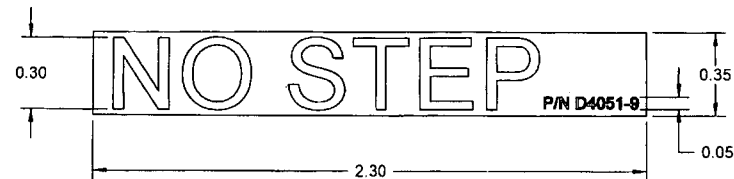
RELEASED
2010-02-16
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4051-5: 0.02 lbs
D4051-7: 0.004 lbs

W10160280

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4051	SHEET 6 OF 7
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D4051-9 PLACARD

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2010-02-16
AW

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE BACKGROUND AND SELF-ADHESIVE BACK.
MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

W10:60280

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DRAWN	RF		
CHECKED	RF	DRAWING NO. D4051	REV. A
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